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Variations and changes may be made by those skilled in the art without departing from the spirit of the invention.--.

IN THE CLAIMS

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Claim 1 (amended) A cutting tool insert particularly for turning of steel comprising a cemented carbide body and a coating [characterized in that] wherein said cemented carbide body [consists of] contains WC, 6-15[, preferably 9-12,] wt-% Co and 0.2-1.8-wt % cubic carbides of Ti, Ta and/or Nb and a highly W-alloyed binder phase with a CW-ratio of 0.78-0.93[,preferably 0.80-0.91] and [in that] said coating comprises

- a first (innermost) layer of $TiC_xN_yO_z$ with a thickness of <1.5 μm, and with equiaxed grains with size <0.5 μm

- a second layer of $TiC_xN_yO_z$ with a thickness of 2-5 μm with columnar grains with an average diameter of <5 μm and

- an outer layer of a smooth, fine-grained (0.5-2 μm) κ-Al_2O_3[-layer] with a thickness of 0.5-6 μm.

Claim 2 (amended) The [C]cutting tool insert [according to any of the preceding claims characterized in that the] of claim 1 further comprising an outermost layer [is] of a thin 0.1-1 μm TiN-layer.

Claim 3 (amended) The [C]cutting tool insert [according to] of claim 2 [characterized in that] wherein the outermost TiN-layer has been removed along the cutting edge.

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Claim 4 (amended) A [M]method of making an insert for turning comprising a cemented carbide body and a coating [characterized in that] wherein a WC-Co-based cemented carbide body with a highly W-alloyed binder phase with a CW-ratio of 0.78-0.93 is coated with

- a first (innermost) layer of $TiC_xN_yO_z$ with $x+y+z=1$, [preferably $z<0.5$,] with a thickness of 0.1-1.5 μm, with equiaxed grains with size <0.5 μm using known CVD-methods

- a second layer of $TiC_xN_yO_z$ with $x+y+z=1$, [preferably with $z=0$ and $x>0.3$ and $y>0.3$,] with a thickness of 2-8 μm with columnar grains with a diameter of about <5 μm deposited by MTCVD-technique, using acetonitrile as the carbon and nitrogen source for forming the layer in a preferred temperature range of 850-900°C[.] and

- a layer of a smooth κ-Al_2O_3 with a thickness of 0.5-6 μm[and

-preferably a layer of TiN with a thickness of <1 μm].

Claim 5 (amended) The [M]method [according to the previous claim] of claim 4 wherein [characterized in that] said cemented carbide body has a cobalt content of 9-12 wt% and 0.4-1.8 wt% cubic carbides of Ta and Nb.

Claim 6 (amended) The [M]method [according to the claim 4 or 5] of claim 5 wherein [characterized in that] said cemented carbide body has a cobalt content of 10-11 wt%.

Claim 7 (amended) The [M]method [according to the claim 4, 5 or 6] of claim 4 wherein the [characterized in a] CW-ratio [of] is from 0.82-0.90.

Claim 8 (amended) The [M]method [according to any of the claims 4, 5, 6 and 7] of claim 4 further comprising an [characterized in that the] outermost TiN-layer[, if present,] which is removed along the cutting edge.

Please add the following new claims 9-14.

--9. The cutting tool insert of claim 1 wherein said cemented carbide body contains 9-12 wt% Co and the CW ratio is 0.80-0.91.

10. The cutting tool insert of claim 1 wherein in the first (innermost) layer of $TiC_xN_yO_z$, $z<0.5$ and in the second layer of $TiC_xN_yO_z$, $z=0$, $x>0.3$ and $y>0.3$.

11. The method of claim 4 wherein in the first (innermost) layer of $TiC_xN_yO_z$, $z<0.5$ and in the second layer of $TiC_xN_yO_z$, $z=0$, $x>0.3$ and $y>0.3$.

12. The method of claim 4 wherein the insert contains an outermost layer of TiN with a thickness of <1 μm.

13. The method of claim 12 wherein the CW ratio ranges from 0.82-0.90.

14. The method of claim 12 wherein the outermost TiN-layer is removed along the cutting edge.--

IN THE ABSTRACT OF THE DISCLOSURE

The above-identified application does not contain an Abstract of the Disclosure. Please add the attached Abstract of the Disclosure.

REMARKS